

Work Order ID 82591

82591

Page 1

April-03-12 10:36:53 AM

Item ID: D2012-111 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 03/04/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 17/04/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/03 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2012-111 | Rev A | | | | | (24) | | | |

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D2012-111
 304 - 063 Dwg Rev: A
 Prog Rev: A
 2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

Handwritten notes: B12-5-1, 5/26/12, 24, 12-5-1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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NOTE: Date & initial all entries

Work Order ID 82591***82591***

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April-03-12 10:36:53 AM

Item ID: D2012-111

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 03/04/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00


160

QC

Memo

0.00

Quality Control

12/5/3 

12-05-3

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

April-03-12 10:36:57 AM

Page 1

Work Order ID: 82591

82591

Parent Item: D2012-111

D2012-111

Parent Item Name: Bracket

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: C00.05.02Now laser cutEC

IPP D 07.01.24 waterjet EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S16GA | | Purchased | No | | | 100 | sf | 261.7520 | 0.0215 | 0.271579 | | | |

M304S16GA

304/316 Sheet .063

1812-5-1

Location

Loc Qty

Loc Code

MAT020

261.752

120866

39.946

120877

143.306

121070

78.5

120866

64

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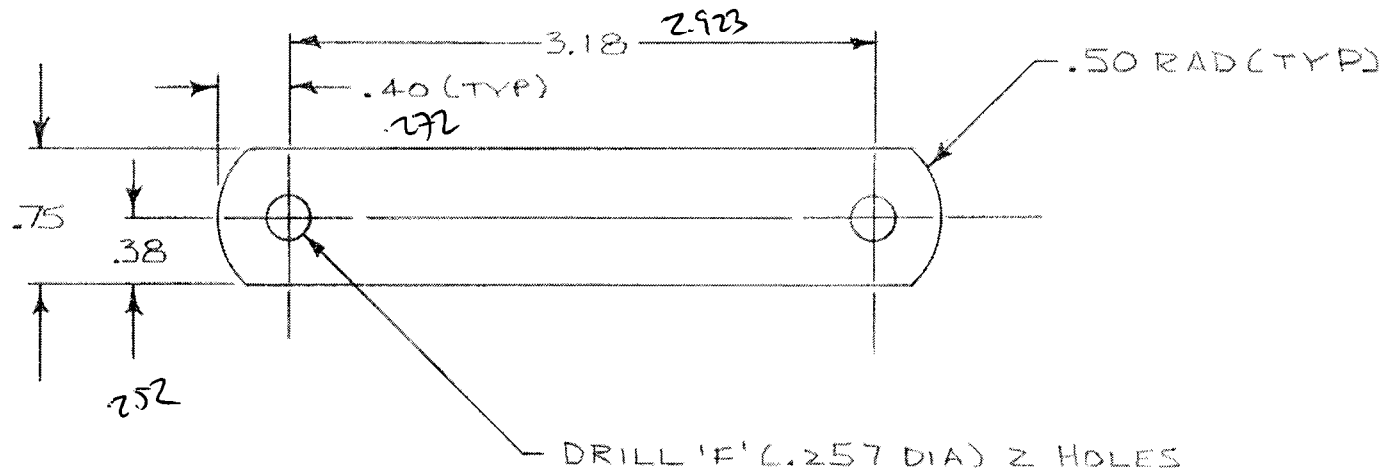
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82591 *MLJ*

12/04/03



NOTES: 1. MAT'L AISI 304/316 CRES
.063 THICK

D2012-111

| | | | | | | | | | | | |
|---|---|----------|---|--|--|--------------------------------------|------------------------|--|----------|--------------|--|
| REDRAWN FROM D2012-111 3/92 | A | REVISION | THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COM'D OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO. | RIVET CODE SHALL BE PER NAS 523 | | PART NO. | ITEM | DESCRIPTION | MATERIAL | SPEC./VENDOR | |
| | 44 | DRAWN | | BASIC CODE | DA DASH NO. H=HEAD REAR SIDE F=HEAD FAR SIDE | CONTRACT NO. | | DART DART AERO ACCESSORIES INC. VANCOUVER CANADA | | | |
| | 28 | APPROVED | | 0=DIMPLE DIOT=NO OF SHEETS C=COUNTERSINK | LENGTH DASH NO W=SPOTWELD | DRAWN HATTON DATE 06/03/92 | | | | | |
| | REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL LIMITS | | | BASIC CODES | | DESIGN BRADLEY DATE 90/9/31 | TITLE BRACKET | | | | |
| | 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS .125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH: S — 32 X 2 5. HOLES PER AND 10287 | | | 1. TOLERANCES — .001 & .030 2. ANGLES .125 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005 | | CHECKED BRADLEY DATE 9/16/8 | CORR DATE 9/16/8 | DWG NO D2012-111 | | REV A | |
| REPORT ALL DISCREPANCIES — DO NOT SCALE | | | | | | | | | | | |

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